

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020284**Date Inspected:** 15-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng, Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10, OBG BIKE PATH (NWIT # 06966, GREEN TAG NO. 13746)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT reports for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004A3-028-002, 010

BK004A5-028-002, 008

BAY 11, OBG BIKE PATH (NWIT # 06960)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

WELDING INSPECTION REPORT

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BK004A2-017-016, 018

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 11, OBG BIKE PATH

FCAW welding of weld joint 025 & 026 located on BK004A3-023.

Welders are identified as 040759, 049220, 040704 & 042218. ZPMC QC is identified as mr. Shao Hai Lanh.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

SMAW welding of weld joints 015 & 016 located on BK004A8-020.

Welder is identified as 046769. ZPMC QC is identified as Mr. Shao Hai Lang.

The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

BAY 10, OBG BIKE PATH

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as BK004A-031. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Sun Tian Liang was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) number HSR1(B)-9343.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
